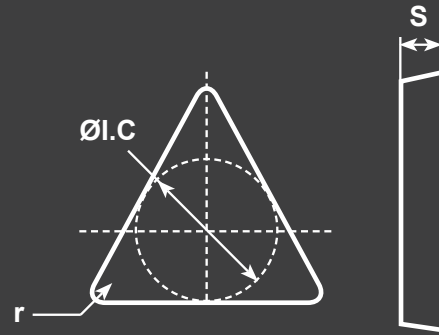


TPGN

Compatible Workpiece Materials



SKU#	ANSI#	ISO#	ØI.C	S	r	START SPEED	START FEED
424-1799	TPGN-221	TPGN110304	0.25	0.125	0.016	P Vc: 1180sfm (920-1570)	fz: 0.008in/z (0.004-0.016)
424-1801	TPGN-321	TPGN160304	0.375	0.125	0.016	P Vc: 1180sfm (920-1570)	fz: 0.008in/z (0.004-0.016)
424-1802	TPGN-322	TPGN160308	0.375	0.125	0.031	P Vc: 1050sfm (850-1310)	fz: 0.008in/z (0.004-0.016)
424-1806	TPGN-432	TPGN220408	0.5	0.187	0.031	P Vc: 1180sfm (920-1580)	fz: 0.008in/z (0.004-0.016)

Material	Coated cemented carbide																		Cermets	Coated Cermets	Cemented Carbide					
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102				YBD151	YBD152	YBD252	YNG151	YNG151C
P Steel	+	+	○	○	-	-	+		○	○													+	+		
M Stainless Steel							+		○	○		+	○	○	○								+	+		
K Cast Iron																	+	○	○	-	-					-
N Ferrite Materials																								○	-	
S Heat-resistant steel							+	+			+					+								+		

+ Good Working Conditions

○ General Working Conditions

- Adverse Working Conditions